TEST REPORT

REPORT NUMBER: 3179893TOR-225 PVCCM
ISSUE DATE: April 14, 2010

EVALUATION CENTER
Intertek
6225 Kenway Drive
Mississauga, Ontario L5T 2L3

RENDERED TO

Artistic Skylight Domes Ltd.
2 Guided Court
Etobicoke, ON M9V 4K6

Attention: Nenzio Ferrazzo

PRODUCT EVALUATED: PVCCM Fixed Skylights
EVALUATION PROPERTY: Physical Tests

Report of Testing for Artistic Skylights Domes Ltd. on PVCCM curb-mounted fixed plastic skylight for compliance with the applicable requirements of the following criteria: AAMA/WDMA/CSA 101/I.S.2/A440-08 *"NAFS North American Fenestration Standard/Specification for windows, doors, and skylights"* and AAMA/WDMA/CSA 101/I.S.2/A440S1-09, *Canadian Supplement*.

1 Table of Contents

Report of Testing for Artistic Skylights Domes Ltd. on G-PVCCM curb-mounted fixed glass skylight for compliance with the applicable requirements of the following criteria: AAMA/WDMA/CSA 101/I.S.2/A440-08 *"NAFS North American Fenestration Standard/Specification for windows, doors, and skylights"* and AAMA/WDMA/CSA 101/I.S.2/A440S1-09, *Canadian Supplement*.

2 Introduction

Intertek has conducted performance testing for Artistic Skylight Domes Ltd. on two G-PVCCM curb-mounted fixed glass skylights for the Intertek Certification Program.

(A) 48"×48"
(B) 67"×89-1/2"

The skylights were submitted to the Intertek laboratory in Mississauga, Ontario on November 9, 2009. Testing was conducted in accordance with the standard methods of AAMA/WDMA/CSA 101/I.S.2/A440-08 *"NAFS North American Fenestration Standard/Specification for windows, doors, and skylights"* and AAMA/WDMA/CSA 101/I.S.2/A440S1-09, *Canadian Supplement*. This evaluation began November 9, 2009 and was completed March 5, 2010.

3 Test Specimen

3.1. SPECIMEN AND ASSEMBLY DESCRIPTION

Designations: (CAN)
- A - Class R-PG1200 (metric)-Size Tested 1346×1346 mm - SKP/RW
- B - Class R-PG1200 (metric)-Size Tested 1830×2405 mm - SKP/RW

(US)
- A - Class R-PG25-Size Tested 53.0×53.0 in - SKP/RW
- B - Class R-PG25-Size Tested 72.0×94.7 in - SKP/RW

Model:
- PVCCM Skylight

Type:
- Curb-mounted, aluminum capped, plastic frame fixed plastic dome skylight

Manufacturer:
- Artistic Skylight Domes Ltd., 2 Guided Court, Etobicoke ON M9V 4K6

Condition:
- New and undamaged

Overall Frame Size:
-

Skylight No.	Width	Height
A	1346 mm (53")	1346 mm (53")
B	1830 mm (72")	2405 mm (94-11/16")

Frame:
- Extruded vinyl main frame members (Extrusion Profiles Die No. V-413) with mitred and welded corners.
- Aluminum Cap- Extruded aluminum cap members (Spectra Aluminum Products Die No. SS-1880) having mitred corners fastened with one #6×1-1/4" pan head screw and a chevron corner key. The corners were liberally sealed with silicone on the backside.

Frame (cont'd):

- Installation: The unit was installed onto a 2x6 wood support frame with 1/2" plywood sheathing secured to one face, simulating a flat roof surface, the frame measuring 2438 mm (96") square overall. The skylight was installed over a centrally located opening, its perimeter lined with 2x6 wood members on the interior, and 2x6 wood members on the exterior forming a curb on the surface of the "roof".

Skylight No.	Size of Curb Opening	
	Width mm (in.)	Height mm (in.)
A	1222 (48-1/8)	1222 (48-1/8)
B	1695 (66-3/4")	2267 mm (89-1/4)

The order of installation was as follows:

- The exterior of the plywood was faced with self-adhering peel-and-stick waterproofing membrane, the membrane continuing up the sides of the curb members and across the exterior face, terminating at the edge of the curb opening. Joints in the membrane were lapped over each other, the membrane being applied using a torch.
- Sections of angle-shaped brake formed 0.46 mm (0.018") thick aluminum flashing were installed along the curb, the 111 mm (4-3/8") leg of the flashing partially covering the side of the curb while the 16 mm (5/8") return partially covered the exterior face of the curb. Along the head and sill, one piece of full length flashing was used, along each jamb, two sections were used per jamb, the sections lapped over one another by 13 mm (1/2"). The flashing was retained by 1-5/8" long roofing nails
- The exterior face of the curb was fitted with an adhesive-backed closed cell foam tape gasket measuring 19 mm wide by 9.5 mm thick (3/4"×3/8"), its corners butted together. This gasket was applied to the exterior face of the curb such that it covered the joint formed between the flashing edge and the underlying membrane.
- The skylight frame was installed onto the curb, the foam gasket sandwiched between the exterior face of the curb and the backside of the skylight frame. The skylight frame was secured to the curb using #10×1-1/2" hex head self-drilling tek screws complete with a composite metal flat washer with a rubber gasket bonded to the underside of it.

Skylight No.	Number of Installation Fasteners (To curb)	
	Head / Sill	Jambs
A	5	5
B	6	7

Note: *For air tightness testing only, the inside perimeter of the skylight support frame opening was sealed with red air barrier tape to the inside perimeter of the PVC skylight frame such that the 2x6 curb-to-PVC skylight frame joint was sealed as well as the joint between the 2x6 curb, the plywood sheathing, and 2x6 wood support members lining the opening. The tape was removed for water tightness testing.*

Drainage:

- None

Glazing:

- Sample A- Two domed layers of nominally 3.2 mm (0.125") thick acrylic plastic (Plaskolite) with a 6.4 mm (1/4") air space, the two layers separated about the perimeter with double sided adhesive backed closed cell foam tape (continuous at three corners) measuring 9.5 mm wide by 6.4 mm thick (3/8"×1/4") sandwiched between the layers The tape joint at the fourth corner was sealed with silicone.
- Sample B- Two domed layers of nominally 3.8 mm (0.150") thick acrylic plastic (Plaskolite) with a 6.4 mm (1/4") air space, the two layers separated about the perimeter with double sided adhesive backed closed cell foam tape (continuous at three corners) measuring 9.5 mm wide by 6.4 mm thick (3/8"×1/4") sandwiched between the layers The tape joint at the fourth corner was sealed with silicone.

Glazing Method:

- Laid in glazed on the interior on a bed of silicone measuring nominally 13 mm (1/2") wide applied on a co-extruded flexible vinyl glazing gasket (Vinyl Profiles Part No. V-76), and retained with the extruded aluminum capping on the exterior, double-sided adhesive backed closed cell foam tape measuring 6.4 mm wide by 3.2 mm thick (1/4"×1/8") being sandwiched between the exterior of the glazing unit and the back side of the aluminum capping. The corners of the sealed unit were also sealed to the back-side of the capping with silicone. The aluminum cap was fastened to the skylight frame using #8×3/4" self-drilling tek screws installed through the side of the capping.

Skylight No.	Number of Aluminum Cap Fasteners	
	Head/Sill	Jambs
A	6	6
B	7	9

Drawings:

- *Plan and Cross-Section Drawing:*
  Artistic Skylight Domes drawing PVCCM, undated

- *Component Drawings:*
  Vinyl Profiles Ltd. Drawing No. V-413, titled “Curb Mount Frame”, dated March 24, 2009
  Spectra Aluminum Products Die No. SS-1880, titled “Retaining Frame”, dated Nov/30/2000

Drawings are enclosed with this report in Appendix A.

4 Testing and Evaluation Methods

The Unit Skylight (glazed with glass) (SKGP) skylights as described in this report was tested to the Residential (R) Performance Class as follows: (The skylight met the Gateway Performance Requirements, by virtue of meeting the higher (optional) performance grades to which they was tested):

- Minimum Gateway Test Size: 500 mm × 1100 mm
- Maximum Allowable Air Leakage: 1.5 L/s•m² (0.3 cfm/ft²) (US)
- Maximum Allowable Air Leakage: 0.2 L/s•m² (0.04 cfm/ft²) (FIXED Canadian)
- Minimum Water Pressure: 140 Pa (2.9 psf)
- Minimum Design Pressure: 720 Pa (15 psf)
- Minimum Structural Pressure: 1440 Pa (30 psf)

The skylights were tested for compliance to the above test criteria in order to achieve the Gateway Performance Designation of Class R-PG15 / R-PG720. The skylights tested had an overall size as follows:
A- 1346 mm wide by 1346 mm high (53" × 53")
B- 1830 mm wide by 2405 mm high (72" × 94-11/16")

Performance testing was conducted in order to meet the overall Optional Performance requirements as follows:

A- 48" × 48"

- Optional Water Pressure: 580 Pa (12 psf)
- Optional Water Pressure (Canada): 730 Pa (15.2 psf)
- Optional Positive Design Pressure: 1200 Pa (25 psf)
- Optional Negative Design Pressure: 1200 Pa (25 psf)
- Optional Positive Structural Test Pressure: 2400 Pa (50 psf)
- Optional Negative Structural Test Pressure: 2400 Pa (50 psf)
- Canada (only) Air Infiltration/Exfiltration Level: Fixed

B- 67" × 89-1/2"

- Optional Water Pressure: 580 Pa (12 psf)
- Optional Water Pressure (Canada): 730 Pa (15 psf)
- Optional Positive Design Pressure: 1200 Pa (25 psf)
- Optional Negative Design Pressure: 1200 Pa (25 psf)
- Optional Positive Structural Test Pressure: 2400 Pa (50 psf)
- Optional Negative Structural Test Pressure: 2400 Pa (50 psf)
- Canada (only) Air Infiltration/Exfiltration Level: Fixed

DEVIATION FROM THE TEST STANDARD

Testing was not initiated at the minimum Gateway grade levels for the SKG-R class of skylights in all incidences of testing. As testing was performed in conjunction with other skylight test standards, the skylight was tested to the Optional Performance Grades of AAMA/WDMA/CSA 101/I.S.2/A440-08. By default, the minimum Gateway requirements were met by virtue of meeting the requirements at higher test levels.

4.1. AIR LEAKAGE RESISTANCE TEST (Clause 5.3.2)

The Air Leakage Resistance test was performed in accordance with ASTM E283-04, "*Standard Test Method for Determining Rate of Air Leakage Through Exterior Windows, Curtain Walls, and Doors Under Specified Pressure Differences Across the Specimen*."

Air infiltration and exfiltration tests were performed using test pressures of 75 Pa (1.57 psf). The maximum air leakage rate was calculated and compared to the allowable air leakage.

4.2. WATER PENETRATION RESISTANCE TEST (Clause 5.3.3)

The Water Tightness test was conducted and evaluated in accordance AAMA/WDMA/CSA 101/I.S.2/A440-08, Section 5.3.3.4, in conjunction with ASTM E331-00, "*Standard Test Method for Water Penetration of Exterior Windows, Skylights, Doors, and Curtain Walls by Uniform Static Air Pressure Difference*".

The Water Tightness test was performed with the skylight installed into a make-shift roof opening as installed by the client, the installation details contained herein. For the water penetration test, the roof was placed at a 15° incline from horizontal at the specified pressure differential and a water spray rate of at least 204 L/m² per hour (5.0 US gal/ft² per hour). The test duration was 15 minutes.

4.3. UNIFORM LOAD TEST (Clause 5.3.4)

4.3.1 Uniform Load Deflection Test (Clause 5.3.4.2)

The Uniform Load Deflection test was conducted in accordance with ASTM E330-02, "*Standard Test Method for Structural Performance of Exterior Windows, Curtain Walls, and Doors by Uniform Static Air Pressure Difference*," Procedure A.

The Deflection test was performed in both the positive and negative directions. A load equal to one-half the anticipated allowable load was applied and held for one minute. Deflection measurements were taken at the mid-span and ends of a jamb. The load was then released and deflection readings were taken after a recovery period of not less than one minute nor more than five minutes at zero load. The test specimen was evaluated for permanent damage. The anticipated allowable load was then be applied and held for one minute. Deflection readings were taken. The load was then released; deflection readings were taken after a recovery period of not less than one minute nor more than five minutes at zero load. The test specimen was evaluated for failure or permanent deformation of any part of the skylight that would cause any operational malfunction.

4.3.2 Uniform Load Structural Test (Clause 5.3.4.2)

The Uniform Load Structural Test was conducted in accordance with ASTM E330-02, "*Standard Test Method for Structural Performance of Exterior Windows, Curtain Walls, and Doors by Uniform Static Air Pressure Difference*," Procedure A.

The Structural test was performed in both the positive and negative directions. A load equal to one-half the structural test pressure was applied and held for one minute. Permanent deflection measurements were taken at the mid-span and ends of a jamb. The load was then released and deflection readings were taken after a recovery period of not less than one minute nor more than five minutes at zero load. The test specimen was evaluated for permanent damage. The structural test pressure was then be applied and held for one minute. Deflection readings were taken. The load was then released; Permanent deflection readings were taken after a recovery period of not less than one minute nor more than five minutes at zero load. The test specimen was evaluated for failure or permanent deformation of any part of the skylight that would cause any operational malfunction.

4.4 THERMOPLASTIC CORNER WELD TEST (Clause 5.3.6.2)

Corner weld tests were conducted in accordance with Clause 5.3.6.2 of the AAMA/WDMA/CSA 101/I.S.2/A440-08. Each corner sample was mounted in a test fixture as per Figure 12 of the standard. The frame corners were loaded as per Figure 12 with a gradually increasing load until breakage of the corner occurred. When loaded to failure, the break shall not extend along the entire weld line.

5 Testing and Evaluation Results

5.1 Air Leakage Test (Clause 5.3.2)

A - PVCCM 48"×48"	
Air Infiltration – 75 Pa (1.57 psf)	
Net infiltration:	0.09 L/s (0.20 cfm)
Total Skylight Area	1.812 m² (19.51 ft²)
Air Leakage Rate:	0.05 L/s·m² (0.010 cfm/ft²)
Air Exfiltration – 75 Pa (1.57 psf)	
Net exfiltration:	0.19 L/s (0.40 cfm)
Total Skylight Area	1.812 m² (19.51 ft²)
Exfiltration rate:	0.10 L/s·m² (0.020 cfm/ft²)

B – PVCCM 67"×89-1/2"	
Air Infiltration – 75 Pa (1.57 psf)	
Net infiltration:	0.09 L/s (0.20 cfm)
Total Skylight Area	4.401 m² (47.37 ft²)
Air Leakage Rate:	0.02 L/s·m² (0.004 cfm/ft²)
Air Exfiltration – 75 Pa (1.57 psf)	
Net exfiltration:	0.05 L/s (0.10 cfm)
Total Skylight Area	4.401 m² (47.37 ft²)
Exfiltration rate:	0.01 L/s·m² (0.002 cfm/ft²)

Maximum allowable air leakage rate:	1.5 L/s·m² (0.3 cfm/ft²)
Maximum allowable air leakage rate (Canadian Fixed):	0.2 L/s·m² (0.04 cfm/ft²)

The PVCSR skylights **MET** the performance levels (as well as FIXED Canadian Infiltration/Exfiltration Levels) specified in AAMA/WDMA/CSA 101/I.S.2/A440-08 for Air Leakage Resistance.

5.2 Water Penetration Resistance Test (Clause 5.3.3)

A- PVCCM 48"×48"	
Pressure Differential	730 Pa (15.2 psf)
Skylight Inclination Angle	0° and 15°
Results:	No water leakage observed.

B – PVCCM 67"×89-1/2"	
Pressure Differential	730 Pa (15.2 psf)
Skylight Inclination Angle	0° and 15°
Results:	No water leakage observed.

The PVCCM skylights **MET** the minimum Gateway Water Penetration Resistance requirement at 140 Pa (2.9 psf), and the Optional Performance requirement for Residential class at 580 Pa (12 psf) in AAMA/WDMA/CSA 101/I.S.2/A440-08. Additionally, the skylight system met the maximum water penetration resistance requirements for Canadian applications at 730 Pa (15.2 psf).

5.3 Uniform Load Test (Clause 5.3.4)

Uniform Load Deflection Test - A- PVCCM 48"×48"		
Member	Jamb	
Span Length	1295 mm (51")	
Allowable Deflection	Report only	
Test Pressure*	***Positive Load***	***Negative Load***
	+1200 Pa (+30 psf)	-1200 Pa (-30 psf)
Maximum Net Deflection	0.00 mm (0.000")	0.28 mm (0.011")
Post-test Details	After the test loads were released, the skylight was inspected and there was found to be no failure or permanent deformation of any part of the skylight that would cause any operational malfunction.	

Uniform Load Deflection Test - B – PVCCM 67"×89-1/2"		
Member	Jamb	
Span Length	2375 mm (93-1/2")	
Allowable Deflection	Report only	
Test Pressure*	***Positive Load***	***Negative Load***
	+2000 Pa (+41.8 psf)*	-2000 Pa (-41.8 psf)*
Maximum Net Deflection	-2.69 mm (-0.106")	0.13 mm (0.005")
Note:	* Deflection data is reported at ±2000 Pa instead of ±1200 Pa	
Post-test Details	After the test loads were released, the skylight was inspected and there was found to be no failure or permanent deformation of any part of the skylight that would cause any operational malfunction.	

5.3 Uniform Load Tests (cont'd)

Uniform Load Structural Test - A- PVCCM 48"×48"		
Member	Jamb	
Span Length	1295 mm (51")	
Allowable Residual Deflection (0.4% × span)	5.18 mm (0.204")	
Test Pressure	***Positive Load***	***Negative Load***
	+2400 Pa (+50 psf)	-2400 Pa (-50 psf)
Residual Net Deflection	-0.44 mm (-0.017")	-0.76 mm (-0.030")
Post-test Details	After the test loads were released, the skylight was inspected and there was found to be no failure or permanent deformation of any part of the skylight that would cause any operational malfunction.	

Uniform Load Structural Test - B – PVCCM 67"×89-1/2"		
Member	Jamb	
Span Length	2375 mm (93-1/2")	
Allowable Residual Deflection (0.4% × span)	9.50 mm (0.374")	
Test Pressure	***Positive Load***	***Negative Load***
	+2400 Pa (+50 psf)	-2400 Pa (-50 psf)
Residual Net Deflection	-0.02 mm (-0.001")	-2.48 mm (-0.089")
Post-test Details	After the test loads were released, the skylight was inspected and there was found to be no failure or permanent deformation of any part of the skylight that would cause any operational malfunction.	

The PVCCM skylights met the minimum Gateway Uniform Load Structural Test (200% of Design Pressure) performance requirements at ±1440 Pa (±30 psf). The skylights met the optional performance requirements as specified in AAMA/WDMA/CSA 101/I.S.2/A440-08 as follows:

Skylight No.	Structural Load Achieved	
	Positive Load	Negative Load
A	+2400 Pa (+50 psf)	-2400 Pa (-50 psf)
B	+4800 Pa (+100 psf)	-3840 Pa (-80 psf)

The PVCCM skylights qualify for the design loads as follows:

Skylight No.	Positive Load	Negative Load
A	+1200 Pa (+25 psf)	-1200 Pa (-25 psf)
B	+2400 Pa (+50 psf)	-1920 Pa (-40 psf)

5.4 Thermoplastic Corner Weld Test (Clause 5.3.6.2)

Frame- Break did not extend along entire weld line.

The skylights met the performance requirements specified in AAMA/WDMA/CSA 101/I.S.2/A440-08 for thermoplastic corner weld test.

6 Conclusion

When tested to the requirements in accordance with AAMA/WDMA/CSA 101/I.S.2/A440-08 *"NAFS North American Fenestration Standard/Specification for windows, doors, and skylights"* and AAMA/WDMA/CSA 101/I.S.2/A440S1-09, *Canadian Supplement,* the PVCCM skylights described and tested herein achieved the following Performance Designations:

Primary Designator

(CAN) A - Class R-PG1200 (metric)-Size Tested 1346×1346 mm - SKP/RW
B - Class R-PG1200 (metric)-Size Tested 1830×2405 mm - SKP/RW

(US) A - Class R-PG25-Size Tested 53.0×53.0 in - SKP/RW
B - Class R-PG25-Size Tested 72.0×94.7 in - SKP/RW

Secondary Designator

A Positive Design Pressure = +1200 Pa (+25 psf)
Negative Design Pressure = -1200 Pa (-25 psf)
Water Penetration Resistance (US only) = 580 Pa (12 psf)
Water Penetration Resistance (Canada only) = 730 Pa (15.2 psf)
Canadian Air Leakage Resistance (Infiltration/Exfiltration) = Fixed

B Positive Design Pressure = +1200 Pa (+25 psf)
Negative Design Pressure = -1200 Pa (-25 psf)
Water Penetration Resistance (US only) = 580 Pa (12 psf)
Water Penetration Resistance (Canada only) = 730 Pa (15.2 psf)
Canadian Air Leakage Resistance (Infiltration/Exfiltration) = Fixed

INTERTEK

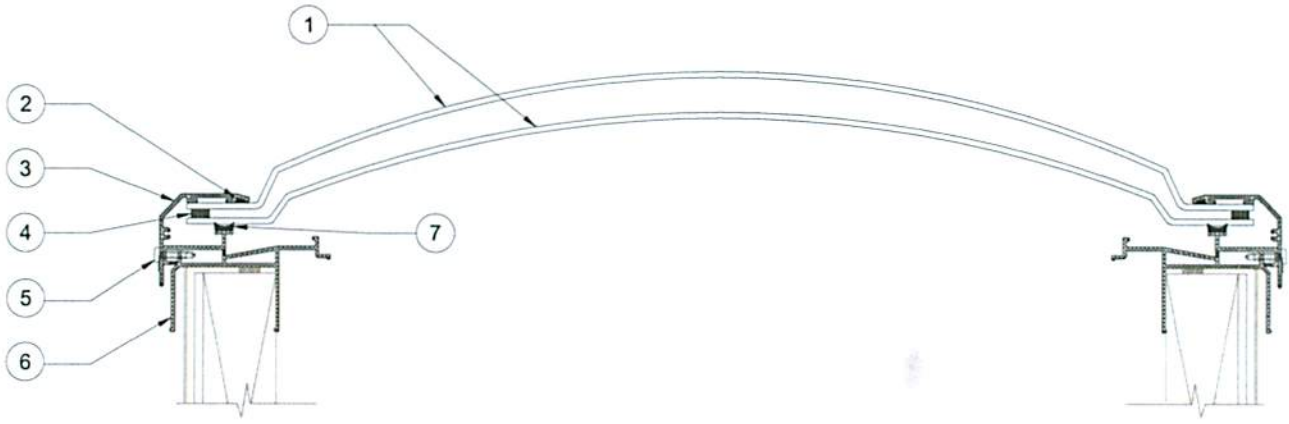
Tested by Mustafa Swalah, Ryan Huynh and Claudio Sacilotto

Reported by: _____
Claudio Sacilotto
Physical Testing Services

Reviewed by: _____
Ryan Huynh
Physical Testing Services

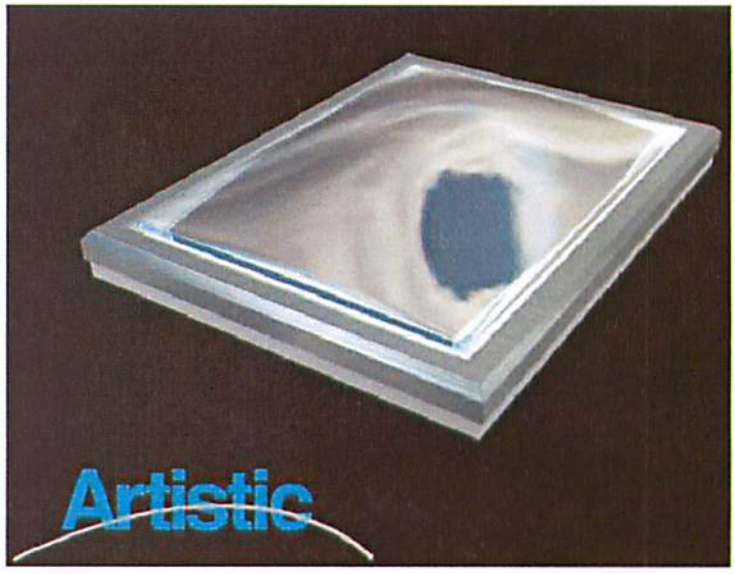
Appendix A – Parts List / Drawings

(Parts List / Drawings – 3 pages)



MODEL PVCCM (CURBMOUNT FIXED – ACRYLIC DOME GLAZING)

	DETAIL
UNIT 1: DOUBLE DOME	1 – CLEAR ⅛" THK.
	2 – CLEAR ⅛" THK.
UNIT 2: DOUBLE DOME	1 – TRANSPARENT BRONZE ⅛" THK.
	2 – CLEAR ⅛" THK.
UNIT 3: DOUBLE DOME	1 – CLEAR ⅛" THK.
	2 – TRANSLUCENT WHITE ⅛" THK.
UNIT 4: TRIPLE DOME	1 – CLEAR ⅛" THK.
	2 – CLEAR ⅛" THK.
	3 – CLEAR ⅛" THK.
UNIT 5: TRIPLE DOME	1 – TRANSPARENT BRONZE ⅛" THK.
	2 – CLEAR ⅛" THK.
	3 – CLEAR ⅛" THK.
UNIT 6: TRIPLE DOME	1 – CLEAR ⅛" THK.
	2 – CLEAR ⅛" THK.
	3 – TRANSLUCENT WHITE ⅛" THK.



PARTS LIST

MODEL PVCCM (CURBMOUNT FIXED – ACRYLIC DOME GLAZING)

PARTICULAR	MANUFACTURER
1. ACRYLIC GLAZING	PLASKOLITE INC., U.S.A.
2. ⅛" x ¼" DOUBLE FACE VINYL FOAM GLAZING TAPE	GASKA TAPE INC., PART # 623012020
3. EXTRUDED ALUMINUM RETAINING FRAME (6063-T5 ALLOY)	SPECTRA DIE # SS-1880 & AFP DIE # 228
4. ¼"x ⅜" DOUBLE FACE VINYL GLAZING TAPE	GASKA TAPE INC., PART # 623025022
5. #8 – 18 x ¾" ASSEMBLY SCREW	ROBERTSON, CANADA
6. EXTRUDED RIGID THERMAL PVC CURB MOUNT FRAME	VINYL PROFILES LTD., DIE # V-413
7. CO-EXTRUDED RUBBER DRAFT SEAL	EXTRUSION PROFILES INC.

Artistic
SKYLIGHT DOMES LTD

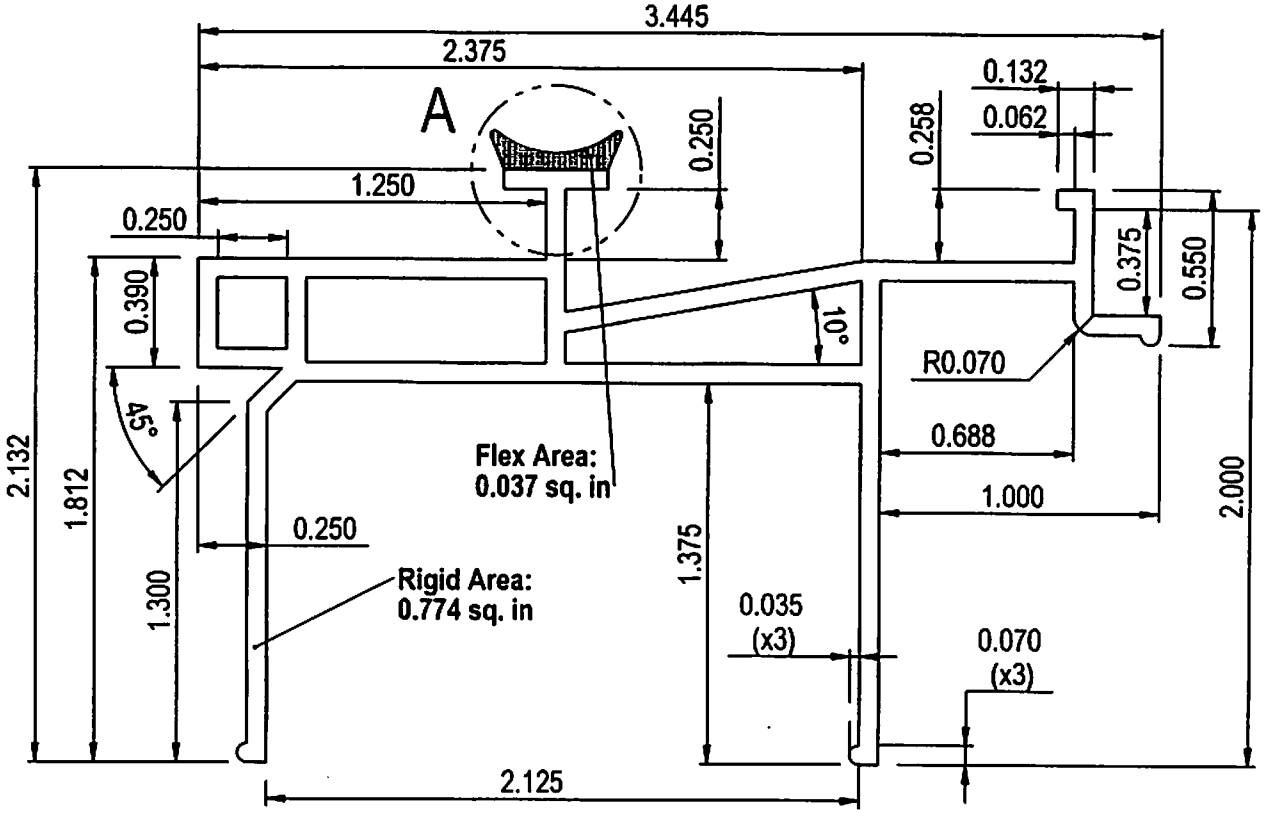
2 Guided Court
Etobicoke, Ontario, Canada M9V 4K6
E-mail: artistic@istar.ca
Web: www.artisticskylight.com

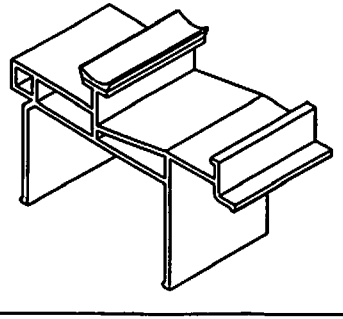
SKYLIGHT MODEL:

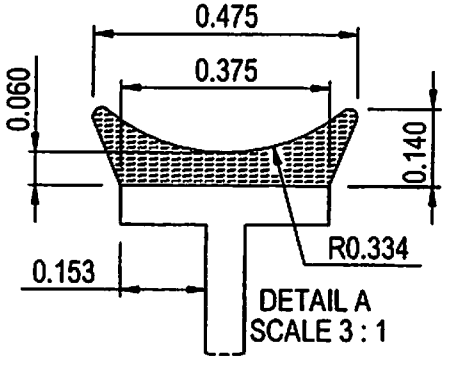
PVCCM

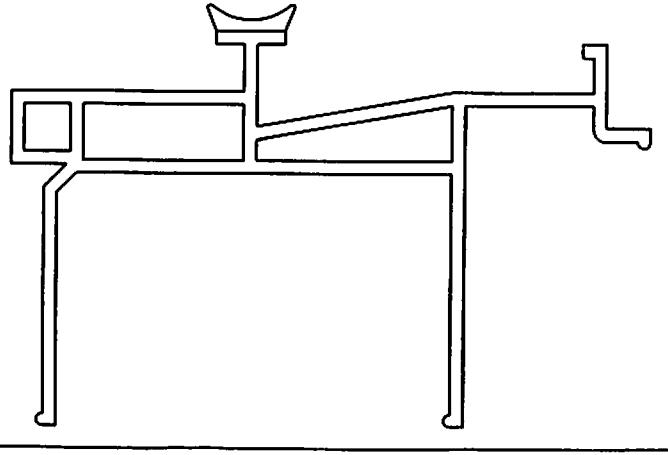
Vinyl Profiles Ltd. CUSTOM EXTRUSION 166 ROMINA DR. VAUGHAN ONT. L4K 4Z7 Tel: 1-905-669-0336 1-905-669-0337 Fax: 1-905-669-0380 E-Mail: vinylpro2ss@bellnet.ca	Customer: Artistic		Date: March 24, 2009	Die #: V-413
	Part Name: Curb Mount Frame		Scale: 1.5:1	Rack #: ----
	Drawing #: V-413	Part#: 328C	Drawn By: S. Q	Area : 0.811 sq. in
	Material: Dual PVC	Color: WHT 143 / Flex-65	Approved By:	Unit: Inch

Wall Thinkness: 0.070"
Typ. Radii: 0.015"









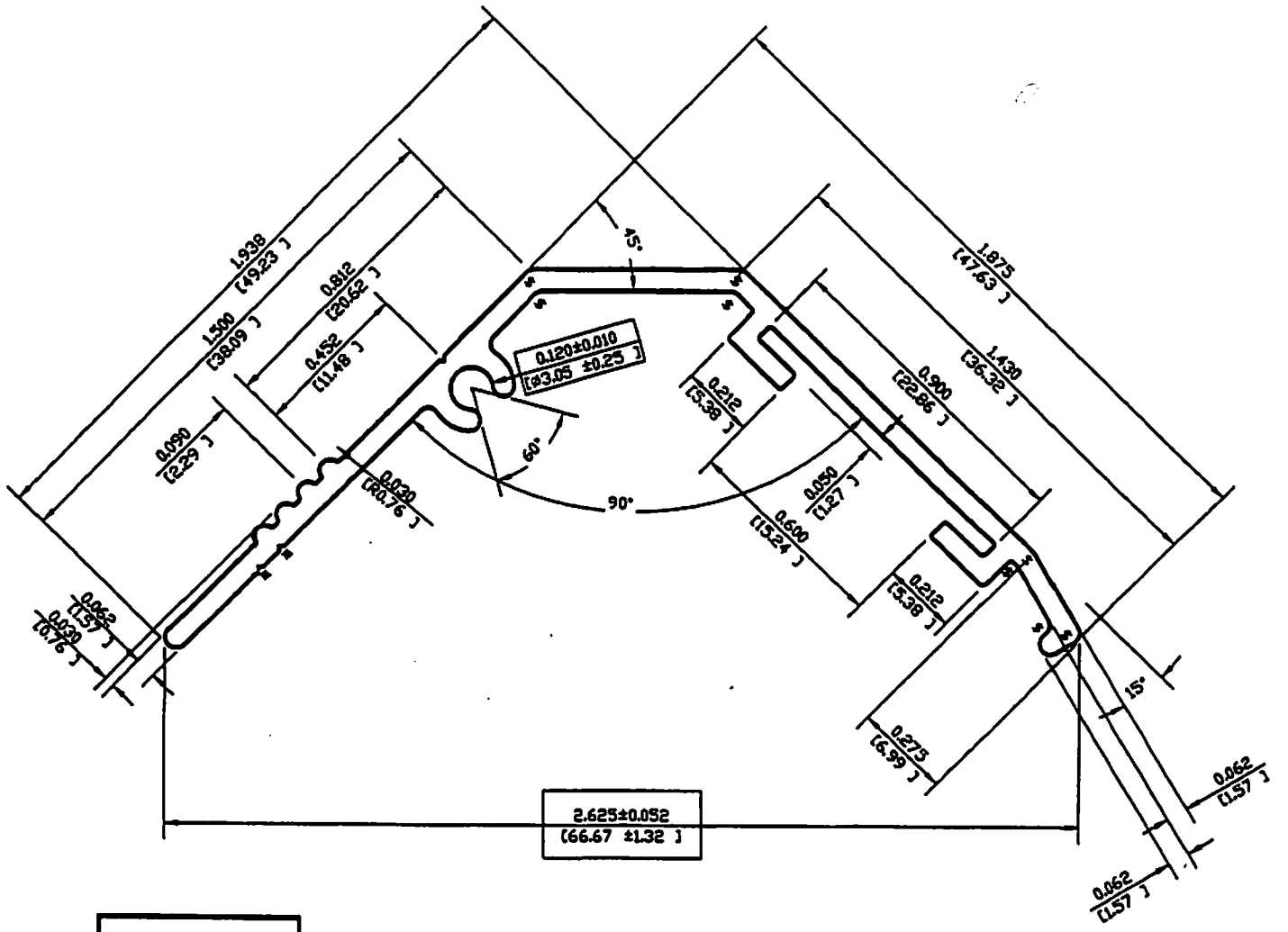
SCALE: 1:1

DESCRIPTION: RETAINING FRAME | PROPOSAL#: SP-12291 | DIE NO: SS-1880

CUSTOMER #: 01187233 | CUSTOMER: ARTISTIC SKYLIGHTS

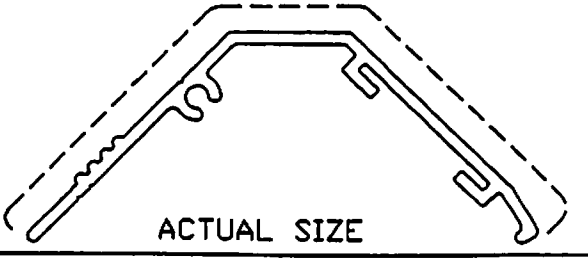
DATE	LET.	REVISION	BY:

SPECTRA ALUMINUM PRODUCTS INC
UNCONTROLLED
Date: FEB 20 2001



CAVITY I.D.

EXPOSED SURFACES



ACTUAL SIZE

NOTE: WALL THICKNESS IS 0.062" [1.57mm] UNLESS OTHERWISE SHOWN
NOTE: BREAK ALL CORNERS AT 0.010" [0.25mm] UNLESS OTHERWISE SHOWN
NOTE: # INDICATES A 0.031" [0.79mm] RADIUS

X.XXX = CRITICAL DIM.
# = 0.010 [0.25] X 90° (SPECTRA ALUMINUM ID MARK)

NOTE: STANDARD ALUMINUM ASSOCIATION TOLERANCES APPLY UNLESS OTHERWISE SPECIFIED.

SPECTRA ALUMINUM PRODUCTS INC

PRICING: WEIGHT ☒	PIECE: ☐	ALLOY: CHECK P.O.	TEMPER: T5		
CSS NO.: 1	CONT'R: 6"	PKT.: 3/4"	EXT. RATIO 50.66		
BACKER NO.: BA-1632-1		DIE SIZE: 8" x 1"			
BOLSTER NO.: BO-28		BACKER SIZE: 8" x 3"	EST. AREA: 0.279 sq.in 180.00 sq.mm	INS. PER: In mm	
GUAGE:	NITROGEN: ☐	CAV.: 2	OUT. PER: 8.811 in 223.80 mm	FACTOR: 26.78	
DWN. BY: S.B.	SCALE: 2:1	DATE: NOV/30/2000	EST. WT.: 0.329 lbs/ft. 0.489 kg/m	C.C.D.: 2.625 in 66.66 mm	